

Work Order ID 126580

126580

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November-14-14 8:42:08 AM

Item ID: D2965 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 11/14/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/14/14 Req'd Qty: 2.00 *2* Customer:

Reference: re-paint black *Rayork*

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2965	Rev B

105		0.00							DAS 41 9-89
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105

SprayPaint

Spray Painting

Memo

PULL FROM STK:
2 X D2965 B99551

PRIME AS PER DWG (REF. 4.2.1.3.2)
A/R PRIMER BATCH: 129850

PAINT MATTE BLACK AS PER DWG (REF. QSI005 4.3)
A/R PAINT BATCH: 127534

115	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
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115

QC

Quality Control

Memo

0.00

(2)

NOV 17 2014

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>FP001</u>	0.00				2	5hp		
190							14/11/18		
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

14/11/18 JF
mf
14-11-18

Picklist Print

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Parent Item: D2965

D2965

Parent Item Name: Cap

Start Date: 11/14/14

Required Date: 11/14/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP: A00.05.31New Issue EC

IPP Rev:Added Turning as per Rev B 06-12-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2965		Manufactured	No				Each	11.0000		2		DAS	
D2965									**			41	
Cap												9-89	14-11-15

Location

Loc Qty

Loc Code

FP001

11

99551

11

2

4.2.2 Paint – Aluminum and Steel Parts

- 4.2.2.1 Mask part per drawing. A light sanding with scotchbrite or 400 grit sandpaper may be necessary for proper paint adhesion. Refer to **NOTE** in section 4.2.1.5.
- 4.2.2.2 Prepare all surfaces to be painted using Dupont 4105S Wash' n' Wipe Degreaser. Be sure not to leave any residue on the parts by passing a good quality tack rag over surface.
- 4.2.2.3 Prepare paint in accordance with manufacturer's instructions.
Acceptable paints are:

Any MIL-C-85285 polyurethane paint
Any MIL-C-83286 polyurethane paint
AWL GRIP G8001 white base + AWL GRIP G3010 converter + AWL GRIP T0003 reducer
White - Dupont Imron Polyurethane Enamel Base white 3.5HG+ (33-24861) or Dupont Imron Flat Polyurethane Enamel Base Black 3.5FT (DUP47-1640-0.8GL).
White – Sherwin Williams Polyurethane with Anti-Mar Teflon Adhesive-additive (CM0143603GA) (Two Coats)
Silver - Dupont Imron Polyurethane Enamel Base quick silver (DUPL0319HL)
Blue - PPG Delfleet 5.0 DFT-005 FBC Blue base coat and PPG Delfleet Clear F3921, mixed with Flattening Binder F3118 ('BL' per 4.7.2)
Clear - Dupont Imron 2.1HG-C clear / HGC-1333 high gloss clear.
Clear – Sherwin Williams – AcryGlo Acrylic Urethane (CM0571080GA)

NOTE: For all Crosstube inspection windows the addition of Polyual 20% Flat is to be added to clear coat per manufacturers recommendations.

- 4.2.2.4 Apply to part surfaces with spray gun until parts are homogeneous in color. Ensure regulator is set correctly for paint mixture type.
- 4.2.2.5 Allow paint flash time, as per manufacturer's instructions, before applying the next coat.
- 4.2.2.6 Apply 2nd coat of paint as required.
- 4.2.2.7 If painting a crosstube, remove masking material at inspection window.
- 4.2.2.8 If painting a Crosstube and the Crosstube has an inspection window, apply clear coat listed in 4.2.2.3 over inspection window area only.
- 4.2.2.9 Allow paint/clear coat to harden to the point that the finish will not be disturbed in further operations.

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